

Work Order ID 80119

Friday, February 10, 2012 10:43:01 AM

80119

Eagle

Page 1

Item ID: D412-785-002-401

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Faceplate

Start Date: 2/10/2012 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 2/17/2012 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: *MVF*

Date: 12-02-10

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D412-785-002-101

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *B*

Prog Rev: *B*

6061-063

2-Deburr as required

B12-2-14

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-2-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Small Fab

0.00

130

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.
COUNTER SINK AS PER DWG

140

Bend as per dwg
NC BRAKE

0.00

140

Brake NC

Memo

0.00

Brake NC

Bend as per Dwg D412-785-002

W/O:		WORK ORDER CHANGES					
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Required Date: 2/17/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

Weld per dwg A/R Aluminum rod Batch: 119185 0.00

160

Large Fab

Memo

0.00

Large Fab

163

~~QC9~~- Inspect visual per QSI004- Fusion Welds

0.00

163

QC

QC10

Memo

0.00


Quality Control

12.02.16

2 φ

(R)

AD →

W/O: 80119		Perm. Long						WORK ORDER CHANGES	
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
2/26/16	#163	change to QC 10		12.02.21			S 2/26/16		

Part No: DH12-785-002-401 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

165

QC5- Inspect part completeness to step on W/O

0.00

165

QC

Memo

0.00

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00

170

HandFinish

Memo

0.00

Hand Finishing

175

QC3- Inspect Part Finish

0.00

175

QC

Memo

0.00

Quality Control

2 12/2/17

2 X 10 m / 12/10/2/17

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QC: Date:

Stop ***NR2***

Tooling: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

180

Identify as per dwg & Stock Location: **(37)**

0.00

180

Packaging

Memo

0.00

Packaging

12/2/17 **MF** **(2)**

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/2/17 **MF**
12-2-17

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Picklist Print

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Page 1

Work Order ID: 80119

Parent Item: D412-785-002-401

Parent Item Name: Faceplate

Start Date: 2/10/2012

Required Date: 2/17/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-08-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	236.5696	1.4	2.9473684		12-2-14	

Location

Loc Qty

Loc Code

MAT021

236.5695684

113608

0

116308

11.4555684

117285

75.414

119331

49.2

119802

25.5

120218

75

117285

(2)

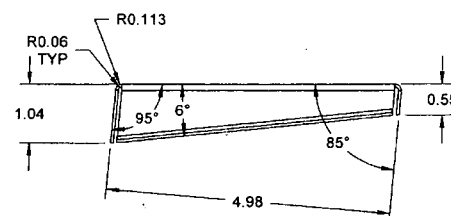
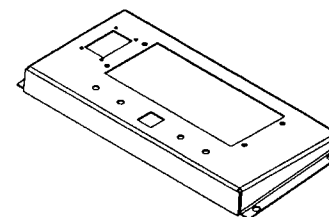
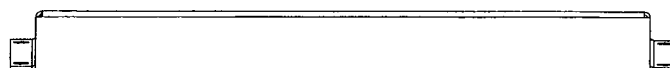
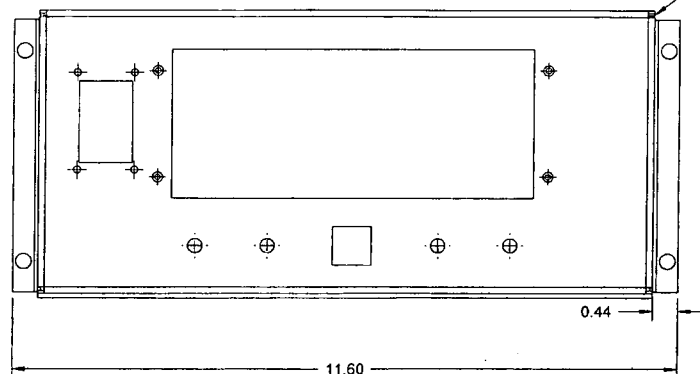
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D412-785-002-401 FACE PLATE
MADE FROM D412-785-002-401F

RELEASED
10/8/25

NOTES:

- 1) MATERIAL: MADE FROM D412-785-002-401F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs
- 8) WELD PER DART QSI 004

DESIGN	RN	EAGLE COPTERS MAINTENANCE	
DRAWN	<i>[Signature]</i>	CALGARY, ALBERTA, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	D412-785-002-101	SHEET 5 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	GPS PANEL INSTALLATION	NTS
DATE	09.10.09	<small>COPYRIGHT © 2008 BY EAGLE COPTERS MAINTENANCE THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM EAGLE AEROSPACE LTD.</small>	

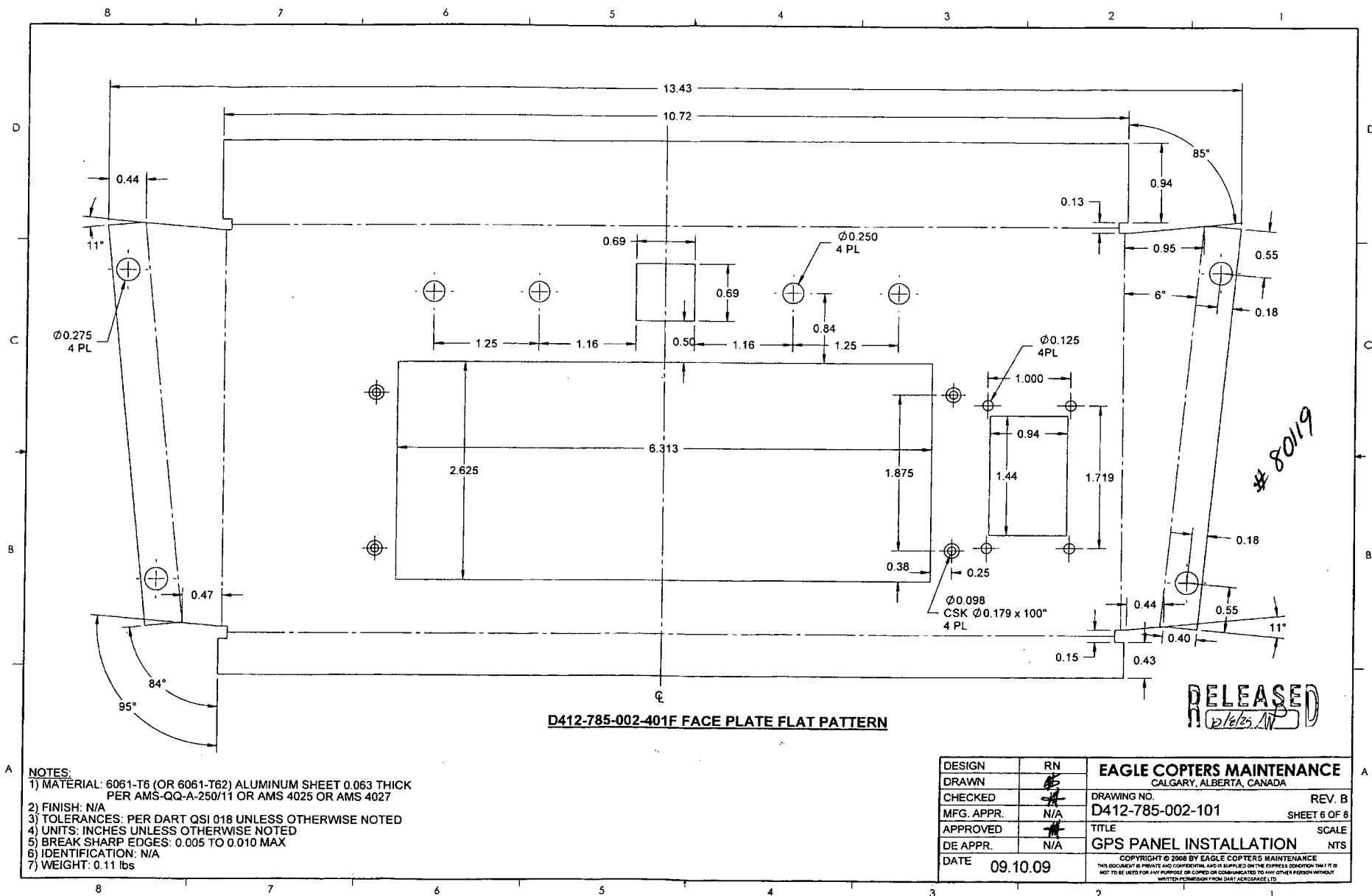
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NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

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